



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4151-1
Job Sheet 179733



Part No: D4151-1

Job Qty: 16 ea

Part Name: Lower Hardpoint Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/21/18

Job Tracking No:

Due Date: 7/18/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C SHEET 2 IPP Rev:A 10.06.24 new issue DD verf:EC IPP Rev:B 11.01.21 as per dwg revC DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	16 Ea	7/18/18	7/18/18	0.00	0.00	Start Up Waterjet		SC 8/07/07
100	Waterjet	16 pcs	7/18/18	7/18/18	0.00	0.61	Waterjet1		SC 8/07/07
120	QC	16 pcs	7/18/18	7/18/18	0.00	0.00	QC8		38
150	Packaging	16 pcs	7/18/18	7/18/18	0.00	0.00	Packaging3	Stop	JUL 9 2018
160	QC21-SA	16 Ea	7/18/18	7/18/18	0.00	0.00	QC21		JUL 12 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	.8128 sf (.0508 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S11GA	1	28	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lower Hardpoint Plate	0.257Inches + 0.006 - 0.001	0.263 0.256	0.259 Diameter	
2	Lower Hardpoint Plate	0.252Inches + 0.003 - 0.000	0.255 0.252	0.253 Diameter	
3	Lower Hardpoint Plate	0.375Inches ± 0.010	0.385 0.365	0.378	
4	Lower Hardpoint Plate	3.128Inches ± 0.010	3.138 3.118	3.130	
5	Lower Hardpoint Plate	1.000Inches ± 0.010	1.010 0.990	1.001	
6	Lower Hardpoint Plate	0.500Inches ± 0.030	0.530 0.470	0.502	
7	Lower Hardpoint Plate	3.660Inches ± 0.030	3.690 3.630	3.666	
8	Lower Hardpoint Plate	2.000Inches ± 0.030	2.030 1.970	2.002	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Quality ☐ Other ☐																																																																	
Date : _____		Step #: _____		Container No: S089837 Part: D4151-1 Job No: 179733 Serial No/Batch: S089837 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/07/18																																																																	
Description Work Order Deviat																																																																					
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9	Lower Hardpoint Plate	1.000Inches $\pm$ 0.003	1.003 0.997	1,002
10	Lower Hardpoint Plate	0.125Inches $\pm$ 0.010	0.135 0.115	0,115

Plex 6/21/18 7:34 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					